

**MOLINS**  
Machine Company Inc

February 23, 1983

**DEFINITION OF DIMENSIONS ON PA85 GUM ROLLERS  
AS USED BY PHILIP MORRIS, U.S.A.**

Dimension "A" equals the width of the double length tipping paper plus 3mm. The 3mm figure allows 1.5mm of tipping paper to extend over the extreme ends of the glue roller grind area thus assuring that gum will be applied to the ends of the tipping paper even if there is paper wander. The Molins or normal standard is 1mm each end.

Dimension "B" equals the dry line which is where the final cut knife on the PA85 cuts the double length cigarette into two individual cigarettes. The Molins or normal standard is 1mm. Philip Morris USA uses .5mm.

Dimension "C" equals one-half "A" dimension (double length tipping paper) plus 1.5mm overlap minus "B" dimension or the dry line.

Dimension "D" equals the normal step where additional gum is applied to assure good adhesion to the filter tip. If no dimension "P" is used (which would be the standard for all companies except Philip Morris Richmond), the "D" dimension equals the length of the additional glue step (reference "K" dimension).

Dimension "E" equals the width of the patch or the band of the skip gap.

Dimension "F" only relates to a dimensional figure from the end of the gum roller, but if used in conjunction with Dimension "M", positions the band relative to the tipping paper or filter.

Dimension "G" is the same relationship as Dimension "F".

Dimension "H" equals the break in the band (Dimension "E") to allow for the tipping paper lap and proper glue joint.

Dimension "I" is in relationship to Dimension "H", i.e. one-half from centerline.

Dimension "J" is the depth of the break and is normally .0015".

Dimension "K" is the additional glue step (reference Dimension "D"). at the cigarette/filter joint, i.e. this is where additional gum or adhesive is applied to the tipping paper to ensure proper adhesion between the filter and the cigarette and to avoid air leaks. This step is normally .00025" and is in addition to the normal glue application across the face of the gum roller (Dimension "L").

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## DEFINITION OF DIMENSIONS ON PA85 GUM ROLLERS AS USED BY PHILIP MORRIS, U.S.A. (continued)

Dimension "L" is the normal step on the glue roller face which establishes the amount of adhesive or gum that is applied to the tipping paper. The normal dimension is .00125".

Dimension "M" basically refers to the starting point from which the glue roller pattern is machined. It is much easier to start from the end of the glue roller than to pick up the center and move in either direction. It is very important in establishing centering of the pattern on the roller.

Dimensions "N" and "P" relate only to a groove which is a Philip Morris USA standard to ensure an additional application of adhesive or gum at the overlap area of the tipping paper on the cigarette.

### GENERAL

The normal procedure for manufacturing a gum roller is to make a blank. We in Molins USA use the Blank SKU 14769 which varies from the Molins London design in that it is a fabrication made up of a gear, the gum roller body and a bushing. The standard Molins London type is made from one piece of material whereas the gear and the bushing are cut out of solid material. They are normally in the part number range of 49079-VAR. We in Richmond prefer to use our design as the scrap rate is lower and manufacture is more economical.

The normal procedure for establishing a PA85 gum roller for skip gap application would be to fill in the attached patch drawing and supply to Molins for conversion and application to the SKU 13806-VAR. glue roller drawing. At this point, customer would be advised what variables had been allocated to his particular patch which was based on the drawing provided.

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